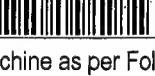
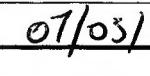
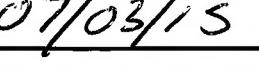


Date: Thursday, 3/8/2007 1:19:10 PM
User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	HINGE BRACKET
Job Number	31123	Part Number	D35381
Estimate Number	12543	Drawing Number	D3538 REV.A
P.O. Number	N/A	Project Number	10254N/A
This Issue	3/8/2007	Type	MACHINED PARTS
Prsht Rev.	NC	Drawing Revision	A
First Issue	N/A	Material	N/A
Previous Run	30866	Due Date	3/30/2007
Written By	HDT, 03.08		
Checked & Approved By			
Comment	Est Rev:A New Issue 06-10-03 EC		
Additional Product Job Number: 			
Seq. #:	Machine Or Operation:	Description:	
1.0	M6061T6B1250X01250	6061-T6 Bar 1.25 x 1.25"	
			
Comment: Qty.: 0.1995 f(s)/Unit Total: 3.9900 f(s) 6061_T6 Bar 1.250" x 1.250 Batch: 103629			
2.0	BAND SAW	BAND SAW	
			
Comment: BAND SAW Cut blanks 1.500" long			
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
			
Comment: 1-Machine as per Folio FA651 and Dwg D3538			
4.0	2-Deburr	m 07/03/14 20	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE			
5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: SECOND CHECK			
6.0	HAND FINISHING1	SECOND CHECK	
			
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1			
			

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/03/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B				Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng		Sign & Date				

NOTE: Date & initial all entries

Date: Thursday, 3/8/2007 1:19:11 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 31123

Part Number: D35381

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 POWDER COATING

POWDER COATING



M103706



20x

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

mk

07/03/15

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SIS 07/03/15

20

9.0 PACKAGING 1

PACKAGING RESOURCE #1



G-A

Took

(2)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/03/15 (18)

To

20

10.0 QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

07/03/19

Job Completion



U 07/03/16

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

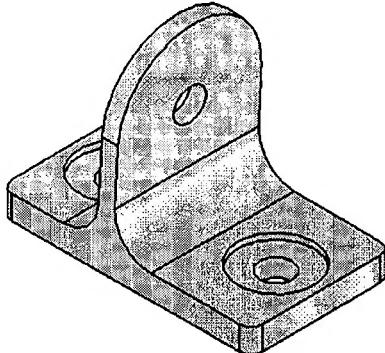
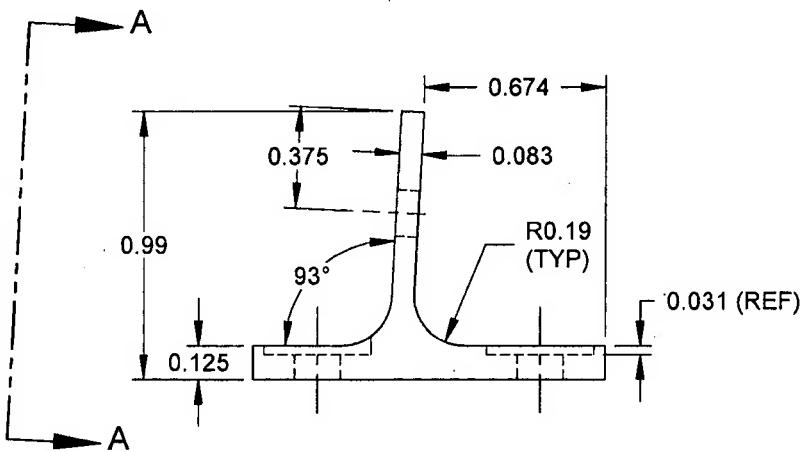
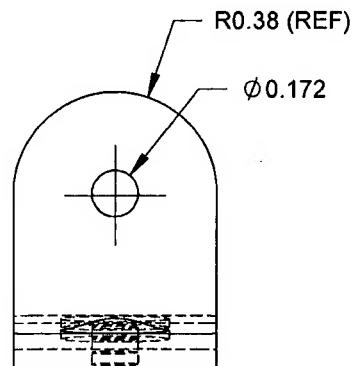
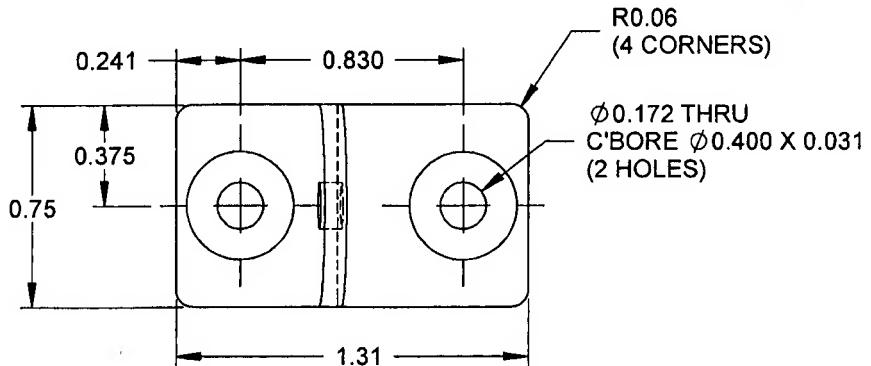
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>CE</i>	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>TH</i>	DRAWING NO. D3538	REV. A	SHEET 1 OF 2
DATE 06.10.13		TITLE HINGE BRACKET	SCALE	1:1
REV A	DATE 06.10.13	DESCRIPTION NEW ISSUE		

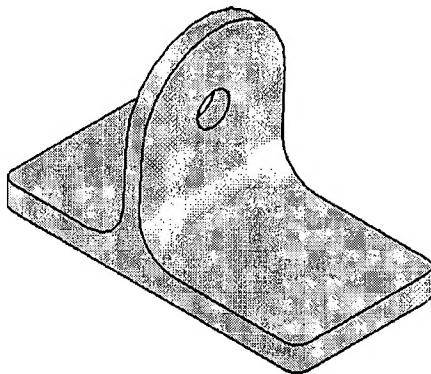
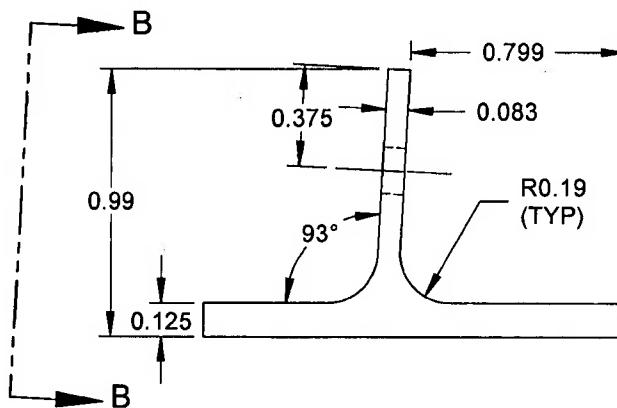
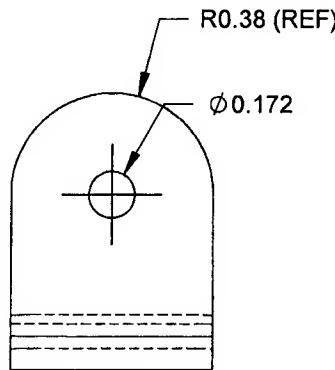
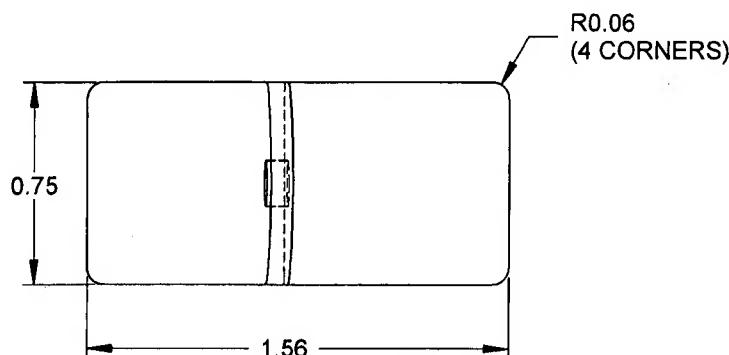
**RELEASED**
06.10.13 TH**AUXILIARY VIEW A****D3538-1 HINGE BRACKET****NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3538-1 USING FINE POINT PERMANENT INK MARKER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *31123*

DART

DESIGN <i>CE</i>	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>CH</i>	DRAWING NO. D3538	REV. A SHEET 2 OF 2
DATE 06.10.13		TITLE HINGE BRACKET	SCALE 1:1

**RELEASED**
06.10.13**AUXILIARY VIEW B****D3538-3 HINGE BRACKET****NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 (REF DART SPEC M6061-T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3538-3 USING FINE POINT PERMANENT INK MARKER

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK CENTER
NO. 31123

DART AEROSPACE LTD	Work Order:	31123
Description: HINGE BRACKET	Part Number:	D3538-1
Inspection Dwg: D3538 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x First Article

■ Prototype

Measured by:	gml
Date:	07/03/14

Audited by: J.F
Date: 07/03/14

Prototype Approval:	<i>NA</i>
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	